



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A93-3312-03-1
Job Sheet 180035



Part No: RBE350A93-3312-03-1

Job Qty: 18 ea

Part Name: Receiver



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 6/27/18

Job Tracking No:

Due Date: 9/4/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBE350A93-3312-03 Rev G IPP Rev A 18.01.23 New issue DP Verify DD/IPP Rev B 18.03.08 DWG update Rev. G DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	18 Ea	9/4/18	9/4/18	0.00	0.00	Start Up Machining-3		(See next page)
120	CNC Lathe	18 pcs	9/4/18	9/4/18	0.00	18.00	MORI SL2500Y		
130	QC	18 pcs	9/4/18	9/4/18	0.00	0.00	QC2 Machining-4		18-10-06
140	QC	18 pcs	9/4/18	9/4/18	0.00	0.00	QC8 Machining-4		
142	Outsource	18 pcs	9/4/18	9/4/18	0.00	0.00	Outsource12 P10:041322		OCT 1 2 2018
144	Packaging	18 pcs	9/4/18	9/4/18	0.00	0.00	Packaging2		OCT 2 2 2018
146	QC	18 pcs	9/4/18	9/4/18	0.00	0.00	QC6		38
200	Packaging	18 pcs	9/4/18	9/4/18	0.00	0.00	Packaging3-1		21
210	QC21-SA	18 Ea	9/4/18	9/4/18	0.00	0.00	QC21		OCT 2 4 2018

Part Op 120 - 1-Machine as per DWG. FB898 FOLIO REV: _____ DWG REV: _____ 2-Debur
Descriptions: 130 - Engrave T/N and/or P/N number using Marktronic engraver as per DWG.
142 - -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140-R2.000	AISI 4140 Round Bar	2.9880 ft (.166 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-4140-R2.000	3	11	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					



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RBE350A93-3312-03-1

Job Sheet 180035



DL-7
7/25

Part No: RBE350A93-3312-03-1

Job Qty: 16 ea

Part Name: Receiver



Part Weight: 0 lbs

Status: At Planning

Priority: Medium

Job Created: 6/27/18

Job Tracking No:

Due Date: 7/16/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBE350A93-3312-03 Rev G IPP Rev A 18.01.23 New issue DP Verify DD/IPP Rev B 18.03.08 DWG update Rev. G DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	16 Ea	7/16/18	7/16/18	0.00	0.00	Start Up Machining-3		18-08-28
120	CNC Lathe	16 pcs	7/16/18	7/16/18	0.00	16.00	MORI SL2500Y		
130	QC	16 pcs	7/16/18	7/16/18	0.00	0.00	QC2 Machining-4		
140	QC	16 pcs	7/16/18	7/16/18	0.00	0.00	QC8 Machining-4		
200	Packaging	16 pcs	7/16/18	7/16/18	0.00	0.00	Packaging3-1		
210	QC21-SA	16 Ea	7/16/18	7/16/18	0.00	0.00	QC21		

Part Op 120 - 1-Machine as per DWG. FB898 FOLIO REV: AA DWG REV: C+ 2-Deburr
Descriptions: 130 - Engrave T/N and/or P/N number using Marktronic engraver as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H900-R2.000	17-4 SS H900 Round Bar 2.000"	2.5600 ft (.16 ea)	90-Start up Operation	5082798 = \$2.788

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-H900-R2.000	3	17	0

Part Specifications

Specifications could not be found.

Plex 6/27/18 4:24 PM dart.logan.david



Container No: S114623



Part: RBE350A93-3312-03-1

Job No: 180035

Serial No/Batch: S114623

Revision: G

Inspector:

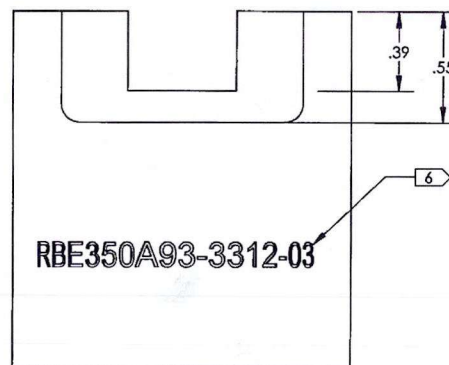
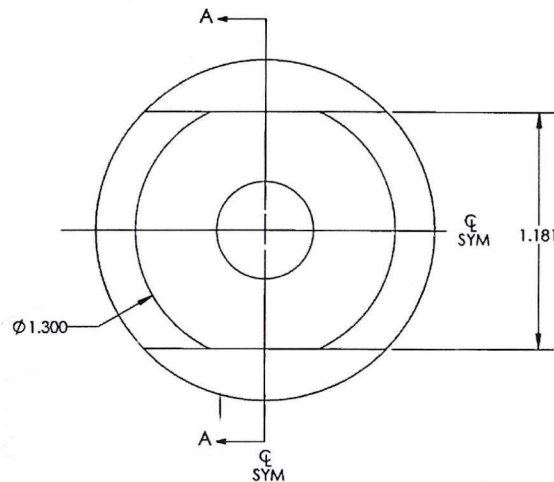
Exp Date:

Instructions:

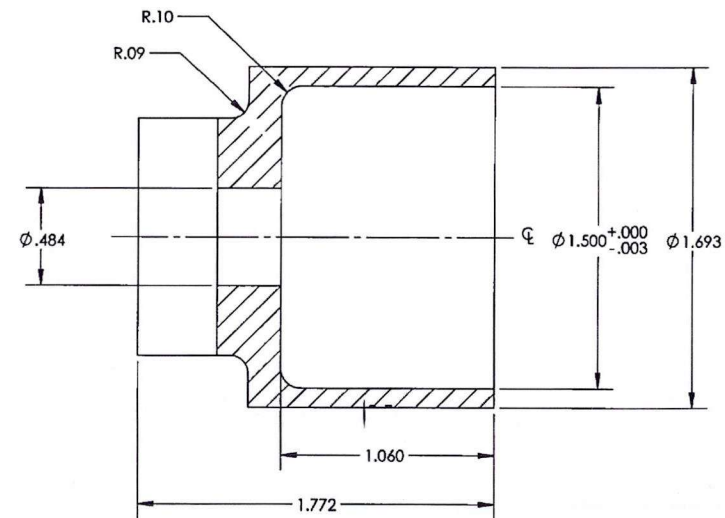
Date: 09/28/18

DAS
13
9-89

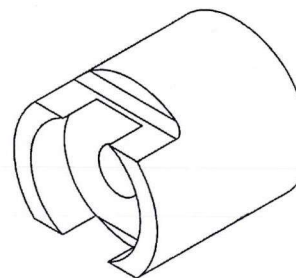
REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
F	TEMPLATE UPDATED, DIMENSION .473 CHANGED TO .484, MACHINE ENGRAVE S/N & MADE IN USA REMOVED, SPEC FOR BLACK OXIDE CHANGED, DIMENSION .54 REF ADDED, 17-4PH SS MTL OPTION ADDED	17-803	17.12.27	VM	ML
G	DIMENSION .55" & .39 ADDED, 28-32 Rc REMOVED	18-582	18.3.1	VM	ML



RBE350A93-3312-03



SECTION A-A



RBE350A93-3312-03-1 RECEIVER

NOTES:

- 1) MATERIAL: 4140/4142 OR 17-4PH-H900 SS
- 2) HEAT TREAT: N/A
- 3) FINISH: 4140/4142 = BLACK OXIDE / 17-4PH = NONE
- 4) SPEC: 4140/4142 = MIL-C-13924, CLASS 1; MIL-C-16173 GRADE 4 / 17-4PH = N/A
- 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
- 6) IDENTIFICATION: MACHINE ENGRAVE T/N "RBE350A93-3312-03", 0.010" DEEP

DART AEROSPACE Hawkesbury, Ontario, Canada	
RECEIVER	
PART NO.	RBE350A93-3312-03-1
TOOL NO.	RBE350A93-3312-03
DESIGNED BY:	VM 12/27/2017
DRAWN BY:	VM 03/01/2018
CHECKED BY:	VM 03/01/2018
MFG REVIEW BY:	DD 03/01/2018
APPROVED BY:	ML 03/01/2018
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES INTERPRET FOR ASME Y14.5M-2009 DIMENSIONS APPLY AFTER FINISHING	
TOLERANCES: XXX ± .005 XX ± .01 X ± .1	
FRACTIONS ± 1/8 ANGLES ± .5° SURFACE ROUGHNESS	
SCALE: NTS SHEET 2 OF 5	
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Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041322**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO041322

PO Date: 10/11/18

Due Date: 10/17/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

E-MAILED
OCT 12 2018

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	180035	RBE350A93-3312-03-1	Receiver -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; -Certificate of Conformity is required	Firmed	-	10/17/18	18 pcs	0 pcs	18 pcs	\$6.6666/pcs	\$120.00
Grand Total:											\$120.00



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PURCHASE ORDER PO041322

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/12/18 10:38 AM dart.lavoie.chantal



Certificat de Conformité / Certificate of Compliance

(013446-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

013446- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
19-Oct-2018		Jessie Boisvert		041322				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Quantités / Quantities				
	Job # / Ref #			Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE350A93-3312-03-1 Rev.	RBE350A93-3312-03-1 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OILMIL-PRF-16173 GRADE 3 CLASS 1	BLACK-OXIDE CH	18	18	0	0	0

Notes Additionnelles / Additional Notes

1 box

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.